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RBE703A95-0520-01-17
Job Sheet 191558



Part No: RBE703A95-0520-01-17

Job Qty: 6 pcs *1021*

Part Name: Engine & Hydraulic Drain Tube Quill Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/4/19

Job Tracking No:

Due Date: 4/18/19

Created By: Marie Lajeunesse

Type: ~~SOLD~~ *stl*

Description:

Note: DWG RBE703A95-0520-00 Rev.J IPP Rev. A 19.02.27 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	6 pcs	4/18/19		0.00	1.20	Small Fab - 1		<i>MLC</i>
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	6 pcs	4/18/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
130	Packaging 3-1 - Stock - B4B	6 pcs	4/18/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



Container No: S170658



Part: RBE703A95-0520-01-17

Job No: 191558

Serial No/Batch: S170658

Revision: J

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/09/19

APR 09 2019

MLC
210
5-89

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				Packaging 3 - 8 - B4B					
				Packaging 3 - 9 - B4B					
				Packaging 3 - 10 - B4B	MLL				
				Packaging 3 - 11 - B4B					
				Packaging 3 - 12 - B4B					
				Packaging 3 - 13 - B4B					
				Packaging 3 - 14 - B4B					
				Packaging 3 - 15 - B4B					
				Packaging 3 - 16 - B4B					
				Packaging 3 - 17 - B4B					
				Packaging 3 - 18 - B4B					
				Packaging 3 - 19 - B4B					
				Packaging 3 - 20 - B4B					
				Packaging 3 - 21 - B4B					
				Packaging 3 - 22 - B4B					
				Packaging 3 - 23 - B4B					
				Packaging 3 - 24 - B4B					
				Packaging 3 - 25 - B4B					
				Packaging 3 - 26 - B4B					
				Packaging 3 - 27 - B4B					
				Packaging 3 - 28 - B4B					
				Packaging 3 - 29 - B4B					
				Packaging 3 - 30 - B4B					
				Packaging 3 - 31 - B4B					
				Packaging 3 - 32 - B4B					
				Packaging 3 - 33 - B4B					
				Packaging 3 - 34 - B4B					
				Packaging 3 - 35 - B4B					
				Packaging 3 - 36 - B4B					
				140 QC 21 - SA	6 pcs	4/18/19	0.00 0.00	QC 21 - SA - 21	DAG
								QC 21 - SA - 70	21
								QC 21 - SA - 53	9-05

APR 09 2019 CAOT6

Part Op 110 - 1-Cut RBE703A95-0520-01-11 as per drawing sheet 5. 2-Cut RBE703A95-0520-01-15 as per drawing sheet 6. 3-Descriptions: Assemble as per drawing note 7. 4-Pack as per drawing.

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
2044T47	Tube Ø1.09	1.9200 ft (.32 ea)	110-Small Fab - 1	5137333
2044T67	Cap Ø1.09	12 Ea (2 ea)	110-Small Fab - 1	8152045
PAD210	Foam Ø1 X 1	.0840 sf (.014 ea)	110-Small Fab - 1	5021250
RBE703A95-0520-01-18	Quill Assembly	6 pcs (1 ea)	110-Small Fab - 1	5170645

Job Allocations

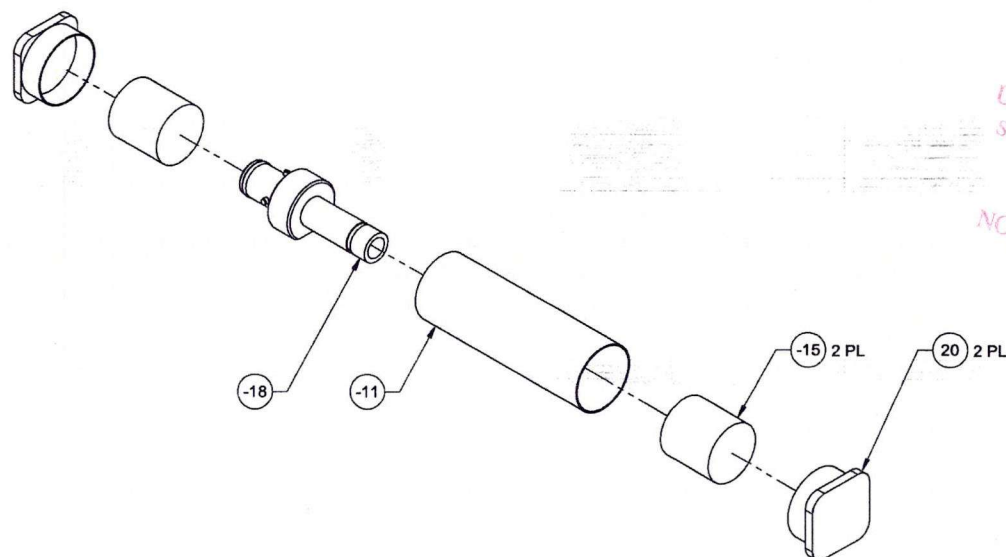
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	2044T47	2	60	0
	2044T67	12	199	0
	PAD210	0	3	0
	RBE703A95-0520-01-18	6	0	0

Part Specifications

Specifications could not be found.

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ITEM #	QTY	PART #	PART TITLE
-11	1	RBE703A95-0520-01-11	TUBE
-15	2	RBE703A95-0520-01-15	FOAM
-18	1	RBE703A95-0520-01-18	QUILL ASSEMBLY
20	2	McMaster#2044T67 OR EQUIV.	VINYL END CAP FOR 1.09" ID. SHIPPING TUBE



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 191558 MOW

19-03-01

RBE703A95-0520-01-17 ENGINE & HYDRAULIC DRAIN TUBE QUILL ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. J
MFG. APPR.	DP	RBE703A95-0520-01	SHEET 2 OF 7
APPROVED	VP	TITLE	SCALE
DATE	2/25/2019	ENGINE & HYDRAULIC DRAIN TUBE	NTS
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QS1042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					